Work Ord May-13-13 1:0		1602			*101	1602*							Page 1
Item ID: Revision ID:	D4030-041				Accept	*N900	040	100	)*	Setu	Start	1.71	S1*
Item Name:	Long Basket	Assembly (350)									Stop	*N	S2*
Start Date:	5/13/13	Start Qty: 1.00	4	*1*		Cust Item I	D:						
Required Date	e: 5/31/13	Req'd Qty: 1.00	<b>.</b>	*1*		<b>Customer:</b>					ŧ.		
Reference:			·<	-							Î		
Approvals:	Process Pla	an: MLJ	Date:	13-05-15	Tooling:	Da	ate:			Run	Start	*N	R1*
Sequence ID/	QC:	<u>,                                </u>					ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t R	eject ty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr											
D4030	С			2 B									
100		Pick Kit			0.00			·- · ·					13 07
*100* Packaging Packaging		Memo			0.00						<del></del> -		13-07-
1 dekaging				, «».									
110 * <b>1</b> 1 <b>0</b> *		Assemble as per dwg			0.00					1	BP	13-9	-16.
HandFinish		Memo			0.00				/-			10 1	- <del>/ =</del>
Hand Finishing		****Mask la sand area for			abel, use scotchbrite re	ed pad to lightly							

0.00

0.00

B7.17

QC5- Inspect part completeness to step on W/O

Memo

\*170\*

Quality Control

1											DQA:	Date:	
NCR: Y	es/	/ No				WORK ORDER NON-C	O	NFORN	AANCE / UP	DATE	·	<del></del>	
											QA Closed:	Date:	
Work Orde	٠÷٠					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK Olde	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No					Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Ì	Date	Step	Qty		or Non-conformance	ļ.	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data		·	otep	α.,	`	or tron comonitation	-						
Equip/Tooling													
Operator	П												
Material													
Setup	П					·		*					
Other	П						1		:				
Process							1						
Supplier							ł						
Training													
Unapproved													
							AUL	T CATE	GORY				
Landi	ng G	Sear				General					•		1
	${m H}$	Bending				Bend	<u></u>	Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Ш	Crushed/	Crimped		ļ	Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination					Contamination	Maintenance				Part Moved		
	Ш	Heat Trea	it			Countersink	L	Mislabe	eled	<u> </u>	Positioned V	Vrong	7
		Inspectio	n Strip in	Tube		Cut Too Short	Misread				Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work	Order	$\mathbf{ID}$ 1	101602
VVUIR	Oruei	117	LUIUUZ

\*101602\*

Page 2

09:44 <u>PM</u>				· · <del></del>	<u>-</u>					
D4030-041			Accept	*N900	040	100	)*	_	17.7	1*
Long Basket	Assembly (350)							Sto	P *NS	2*
5/13/13	Start Qty: 1.00	*1*		Cust Item II	D:					
e: 5/31/13	<b>Req'd Qty:</b> 1.00	*1*	•	<b>Customer:</b>						
	•							· -		
Process P	lan:	Date:	Tooling:	Da	ite:				"NK	1*
QC:		Date:	<b>SPC (Y/N):</b>	Da	ite:			Sto	*NR	2*
ID	Operation Description Identify as per dwg & St	tock Location	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	Number S	nsp. tamp
	Memo	PPP 160	5316					S.	13-7	<i>- 2</i> =
		- Work Order Release	0.00					[3]	1/24	H
	Мето		0.00					al 120	123	
	D4030-041  Long Basket 5/13/13 2: 5/31/13  Process P QC:	D4030-041  Long Basket Assembly (350)  5/13/13 Start Qty: 1.00  e: 5/31/13 Req'd Qty: 1.00  Process Plan: QC:  Operation Description Identify as per dwg & Start Qty: 1.00	D4030-041  Long Basket Assembly (350)  5/13/13 Start Qty: 1.00 *1 *  2: 5/31/13 Req'd Qty: 1.00 *1 *  Process Plan: Date: QC: Date:  Operation Identify as per dwg & Stock Locations  Memo  QC21- Final Inspection - Work Order Release	D4030-041	D4030-041	D4030-041	D4030-041	D4030-041	D4030-041	D4030-041

NCR: Y	es	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPI		QA Closed:	Date	<b>::</b>
Work Orde	er: _					DISPOSITION	1		a	AGAINST DEI	PARTMENT	_	7 c
Part N NCR N	-		***************************************			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
WCK I	٠٠.					Work Order Opdate			<u>۔                                    </u>			Jappine. [	
Root					Descri	ption of work order update	ı	nitial		ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	Щ												
Equip/Tooling					ĺ								
Operator													
Material	Ш								The same of the sa	- E.			
Setup					]								
Other		!			Ì								
Process													
Supplier							ı						
Training													
Unapproved			L	ļ <u>.</u>			<u></u>						
							AUL	T CATE	GORY				
Landi		1				General	_	1		<del></del>	1	_	¬
	Bending					Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
	Ш	<b>→</b>				BOM/Route	<u> </u>	Hardwa		ļ	Over/Under	<b>⊢</b>	Temperature/Cure
	-	· —				Broken/Damaged	<u> </u>	4	on Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
	$\vdash$	1	crushed/Crimped Burrs				$\vdash$	4	ions Incomplete/l	·	Part Lost/Mi	ssing [	Wrong Stock Pulled
	Cuffs Contamination				<del>-</del>	$\perp$	Mainte		<b>——</b>	Part Moved			
	Heat Treat Countersink					<u></u>	Mislabe		<del>}</del>	Positioned V		<b>_</b>	
	_	Inspectio		Tube	<u></u>	Cut Too Short	Misread Power Loss/Surge Other					Other	
		Ripples in				Drill Holes	Offset						
<b>!</b>	1	Torque Waves in Extrusion Drawing						Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

## **Picklist Print**

May-13-13 1:09:43 PM

Work Order ID:

101602

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date: 5/13/13** 

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as per dwg revB DD

10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

IPP Rev D 12 03 27 per NCR12-1239 EC verified by ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location		Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	22.0000		1	- 1.4		
Placard, Max Load											73		
				Location		Loc Qty	<u>L</u>	oc Code					
				ST093		22							
					100556	12							
					88611	2							
					96251	1			<del>_</del> a.	8519			
					98519	7			_7_	0211			
D2530 Handle Weldment		Manufactured	No			100	Each	11.0000	1	1 . 2/30	-7B_		
				<b>Location</b>		Loc Qty	<u>L</u>	oc Code			V		
				ST205		3							
					87086	3							
				ST255		8							
					100263	8			<del> </del>				
D2535 Spring		Manufactured	No			100	Each	26.0000	2	2	-21	B	
				Location		Loc Qty	<u>L</u>	oc Code					
				ST011		26			<del></del>				
					96248	26			44	248			
D2537 Bushing		Manufactured	No			100	Each	114.0000	2	2	123		3-07-12
· ·				Location		Loc Qty	<u>L</u>	oc Code			V		
				ST008		24							
					99011	24							
				ST011		90							
					100454	42							
					94713	24				2001			
					98426	24			9	9476			

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UI		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	٠.				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier											

Landing (	Gear	General				_	_
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	L	Part Moved	_
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	 · · ·
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Г	Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			

Outside Dimensions

**FAULT CATEGORY** 

Wave/Twist in Tube

Folio

Training Unapproved

Work Order ID: Parent Item:	101602 D4030-041							Start I	Date: 5/1	3/13		Required Da	ate: 5/31/13
Parent Item Name:	Long Basket Asse	embly (350)		11	2125				Qty: 1.00			Required C	
D3913-041 Long Basket Base Assen	_	Manufactured	No	μ	13135 .	100	Each	0.0000	1	_/_	1	BL	B-7-12.
D3914-041 Long Basket Lid Asseml	-	Manufactured	No	10	3384	100	Each	0.0000	1	/	1	BL	13-7-12.
<b>D3917-3</b> Washer		Manufactured	No			100	Each	118.0000	6 	02	472	<u>_</u>	THE STREET
				Locatio	<u>n</u>	Loc Qty		Loc Code				0	
				ST072		118							
<u>.</u>					100397	82							
; :					92514	1							
					97710	35		4.5.000	_	,	<del></del>		
D3953-3		Manufactured	No			100	Each	45.0000	2		2	73	
Gas Spring Stud, Lid									C				**************************************
1				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code					
				GA		1							
					87592	1							
				ST075		30							
					100485	30					<u> </u>		
<b>5</b> - ₹,				ST076		14				004	83		
· F					88494	14			_				
D3953-7 Spring Spacer		Manufactured	No			100	Each	65.0000	2	- PAN	2	1/8	
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code				,	
: <b>£</b> ,				ST076		65							
					100414	26	i						
					94669	15				nai	110		
					99148	24			_	991	48		
D3953-9		Manufactured	No			100	Each	45.0000	2		2	71	13-07-12
Gas Spring Washer									<del></del>			-59-	120100
				Locatio	<u>n</u>	Loc Qty		Loc Code					
				ST076		45	;		<del></del>	<del>// ~</del>			
					95127	45	i		_	951	127		

NCR: Y	es	/ No				WORK ORDER NON-C	ON	IFOR!	MANCE / UPI	DATE	QA Closed:	Date	<b>:</b> :
Work Orde	:r: _					DISPOSITION		<u>, , ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ;</u>		AGAINST DE		PROCESS	
Part N	••••					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	Î .	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo				<del></del>	Work Order Update			Large Fab	Composite		Supplier	
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	Į .	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						<del></del>	AUL	T CATE	GORY				
Landir	Bending Centre Not Concentric to O/S Cracks Broken/Dama Crushed/Crimped Bend BOM/Route Broken/Dama Burrs				BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/l enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	101602							
Parent Item:	D4030-041					Start D	Pate: 5/13/13	Required Date: 5/31/13
Parent Item Name:	Long Basket Assembly (350)					Start (	Qty: 1.00	Required Qty: 1.00
D3953-17 Gas Spring Spacer	Manufactured	No		100	Each	24.0000	2	2 -yB
			Location	Loc Qty		Loc Code		
			ST076	24		•		
			97100	4				-,
			97696	20			9769	6
D3953-19 Gas Spring Bracket	Manufactured	No		100	Each	7.0000	1 100341	1-70
			Location	Loc Qty		Loc Code		
			ST077	7				
			97691	7				-
D3953-21 Gas Spring Bracket	Manufactured	No		100	Each	37.0000	1	1 - 23
			<u>Location</u>	Loc Oty		Loc Code		<i>V</i> -
			ST075	9				
			97714	9				-
			ST077	28				_
			100404	28			100 40	4
D3969-3 Spring (Basket Lid)	Manufactured	No		100	Each	26.0000	1	1 - gB
			<u>Location</u>	Loc Qty		Loc Code		V
			ST262	24				
			91844	4				_
			99623	20			99623	3
			ST272	2				_
			97050	2				_
AN3-14A Bolt	Purchased	No		100	Each	45.0000	1257	og 13 13-07-12
			Location	Loc Qty		Loc Code		v
			ST512	45				_
			123759	45				_

NCR: Yes / No											DQA:	Date:	
Work Order:  Part No.  Part No.  Disposition  Rework Scrap Use-as-is Work Order Update  NCR No.  Date Step Qty Description of work order update Caulor Fault Chief Eng Description  Operator  Material Sequip/Tooling Operator  Material Sequip Colon Frocess  Skid-tube Scrop Machining Small Fab Prod. Eng. Coor. Quality Prod. Eng. Coor. Quality Prod. Eng. Coor. Quality Prod. Eng. Coor. Supplier Other Chief Eng Description  Operator Operator  Material Sequip Colon Sign & Verification Operator Chief Eng Description  Material Sequip Colon Sign & Verification Operator Chief Eng Description  Other Other Other Chief Eng Description  Other Other Chief Eng Description  Other Chief Eng Des	NCR: Ye	es / No				WORK ORDER NON-O	CON	IFORM	MANCE / UPDATE				
Work Order:  Part No.  NCR No.  Rework Use-as-is Work Order Update Use-as-is Equip/Tooling Qoperator Material Querient Q											QA Closed:	Date	
Rework Scrap   Skid-tube   Crosstube   Small Fab   Prod. Eng. Coor.   Quality   Qualit	Mork Ordo	<u>.</u> .				DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Part No.   Scrap   Use-as-is   Use-as-is   Work Order Update   Use-as-is   U	Work Order	··				Rework	1		Skid-tuhe Crosstuhe		]	Water let	Engineering
NCR NO.	Part No	0				<u> </u>	1		<b></b>	-	Pro		- ' <del>-</del>
Root Cause Date Step Qty Description of work order update Chief Eng Description Doc/Data Equip/Tooling Operator Material Setup Chief Eng Chief Eng Description Chief Eng Chief E	1 41 (11)	ŭ	<del> </del>			· —	1		<b>∽</b>	-		· · ·	- i
Root Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector  Doc/Data Description Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector  Doc/Data Description Date Verification Date Verificati	NCR N	0.				· · · · · · · · · · · · · · · · · · ·	1			_			1
Cause       Date       Step       Qty       or Non-conformance       Chief Eng       Description       Date       Verification       QC Inspector         Doc/Data		-											
Doc/Data	Root				Descri	ption of work order update	lı	nitial	Action		Sign &		
Equip/Tooling	Cause	Date	Step	Qty	(	or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Operator	Doc/Data												
Material Setup Other Process Supplier Training Unapproved Unapprov	Equip/Tooling	_											
Setup Other Process Supplier Training Unapproved	Operator												
Other Process Supplier Supplier Supproved Supp	Material												
Process Supplier Training Unapproved	Setup										<u> </u>		
Supplier Training Unapproved	Other	_											
Training Unapproved Un	Process												
Unapproved	1 -	_											
	l	_		•									
	Unapproved	L_	<u> </u>	J	<u> </u>				CORY				ļ
							AUL	ICATE	GORY			<del></del>	
Landing Gear General  Bending Bend Grain Ovalized Pressure/Forced	Landin					7		Cusin			Ovalizad		Drossuro/Forcad
	Centre Not Concentric to O/S BOM/Route						$\vdash$			$\vdash$	4	talaransa	┥ :
		<u></u>					$\vdash$			$\vdash$	<b>-</b> 1	<del> </del>	
		Cracks Broken/Damaged					Inspection Incomplete			-	4	<u> </u>	Wrong Stock Pulled
	Crushed/Crimped Burrs						Instructions Incomplete/Unclear						
Heat Treat Countersink Mislabeled Positioned Wrong	<b> </b>	Cuffs Contamination					-			-	-1	Vrong	

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Power Loss/Surge

Other

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID: Parent Item:

101602

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date: 5/13/13** 

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

Parent Item Name:	Long Basket Assembly (550)					Start	Qty. 1.00	Required Qty. 1.00
AN3-16A Bolt	Purchased	No		100	Each	78.0000	125	9=27 Jo
		Loca	<u>tion</u>	Loc Qt	¥	Loc Code		•
		GA		•	<b>4</b> 7			<u> </u>
			117441	•	47			
		ST35	2		31			-
			122407		8			<u></u>
			123900		23		-	
AN5-17A Bolt	Purchased	No		100	Each	254.0000	12	6176 99
		Loca	<u>tion</u>	Loc Qt	¥	Loc Code		•
		GA			36			<u></u>
			117872		36			<del></del>
		ST33			68			
			124215		50			<del></del>
			124805		18			
		ST51			50			
			125388		50			
AN4-12 Bolt	Purchased	No		100	Each	44.0000	3	3 
		Loca	tion	Loc Qt	<u>ty</u>	Loc Code		V
		ST35	56		44			-
			124805		44		124	705
<b>AN310-4</b> NUT	Purchased	No		100	Each	37.0000	12	5752 gB 13-07-12
		Loca	<u>ıtion</u>	Loc Qu	ty	Loc Code		•
		ST34	12		37			
			122800		2			· 
			124221		35			

											DQA:	Date:		
NCR:	<b>Yes</b>	/ No				WORK ORDER NON-C	CONI	FORN	MANCE / UPI		QA Closed:	Date:		
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	In	itial	Act	ion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data	П		,	1										
Equip/Tooling	П													
Operator	П													
Material	П													
Setup	П						1						ļ	
Other	П													
Process	П								i					
Supplier														
Training	П													
Unapproved	П													
				·		F	AULT	CATE	GORY					
Landi	ing G	ear				General					-		-	
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/	Crimped			Burrs		nstruct	ions Incomplete/I	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
1		Cuffs				Contamination		Mainte	nance		Part Moved	<del></del>		
	П	Heat Trea	at			Countersink		Mislabe	led		Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

Parent Item: D4030-041 Parent Item Name: Long Basket Assembly (350)	<b>Start Date:</b> 5/13/13 <b>Start Qty:</b> 1.00	Required Date: 5/31/13
	Start Qty: 1.00	D 1 10: 100
		Required Qty: 1.00
AN310C4 Purchased No 100 Each	58.0000 <b>2 2</b>	-JB
<u>Loc Qty</u> <u>Loc Cty</u>	c Code	•
ST342 58		
123831 2	·	
124221 56	124221	
MS21042L3 Purchased No 100 Each Nut	3,977.0000 6 6 6 	6 78
<u>Location</u> <u>Loc Oty</u> <u>Loc</u>	c Code	
FP001 3		•
122141 3		
GA 18		
122452 18		
ST314 268		·
117885 32		
119017 55		
119075 138		
123265 43		
ST506 3688		
123900 954		
124291 2734	<del></del>	
MS21042L5 Purchased No 100 Each	1,125.0000 4 13563	4 yg 13-07-1:
<u>Location</u> <u>Loc Oty</u> <u>Loc</u>	oc Code	
ST506 125		
123900 125		
st507 1000		
125535 1000		

										DQA:	Dat	e:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	MANCE / UP	DATE			
										QA Closed:	Dat	e:
Work Orde	ar.			:	DISPOSITION	-			AGAINST DE	PARTMENT	/PROCESS	
WOIK Olde	·				Rework	1 I		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is				→	re/Packaging	Other	
NCR No.					Work Order Update Large Fab Composite				Supplier			
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1				1						
Equip/Tooling						ŀ						
Operator												
Material							1					
Setup												
Other		Ì										
Process												
Supplier												
Training												
Unapproved						<u>l</u>						
· · · · · · · · · · · · · · · · · · ·					F	AULT	CATE	SORY				
Landi	ng Gear			_	General	_			_	_	-	_
	Bending				Bend	Щ°	Grain			Ovalized	Ļ	Pressure/Forced
Root Cause Date Step Qty  Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved  Landing Gear		o/s	BOM/Route	$\sqcup$ '	Hardwa	re	<u></u>	Over/Under	tolerance	Temperature/Cure		
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped					Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct [	Weld
	Crushed/	Crimped		L	Burrs	$\blacksquare$		ions Incomplete/	Unclear	Part Lost/M	- L	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	L.	Part Moved		
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	ل Vrong	
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	'Surge	Other
	Rinnles is	n Bend			Drill Holes		Offcot					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Order ID:	101602							
Parent Item:	D4030-041					Start Da	te: 5/13/13	Required Date: 5/31/13
Parent Item Name:	Long Basket Assembly	y (350)				Start Q	ty: 1.00	Required Qty: 1.00
MS24665-151 Cotter Pin		Purchased No		100	Each	90.0000	125646	, <u>g</u> <u>B</u>
			<b>Location</b>	Loc Qty		Loc Code		
			GA	28				
			17566	28				
			ST323	62			·	
			122802	20				
			124859	42				
MS24665-300	J	Purchased No		100	Each	201.0000	2 2	13
Cotter Pin								
			<b>Location</b>	Loc Qty		Loc Code		
			GA	37				
			118234	37				
			ST299	164			1011000	,
			124555	164			124555	
NAS1149F0432P	1	Purchased No		100	Each	1,542.0000	6 6	1 B
Washer								
			<b>Location</b>	Loc Qty		Loc Code		•
			ST295	1542				
			122151	2				
			123522	4				
			123900	32				
			124580 124859	204 300				
			125268	1000			125268	
NAS1149F0563P	,	Purchased No		100	Each	692.0000	4 4	
Washer		ruichaseu						JB 13-07-12
			<b>Location</b>	Loc Qty		Loc Code		V
			ST295	692			_	
			121350	692			121350	
							<del>_</del>	

											DQA:	Date	
NCR: Y	'es /	No				WORK ORDER NON-C	ON	<b>NFORM</b>	AANCE / UP	DATE			
								-			QA Closed:	Date	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
						Rework Scrap	Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor.	Engineering Quality	
NCR N						Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Sto	re/Packaging Supplier	Other
Root				1	Descri	ption of work order update	ı.	nitial	Ac	tion	Sign &		
Cause	Da	ite S	tep	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			- 1	1									
Operator			I				1						
Material		Ì									ļ		
Setup			ŀ										
Other		ł											
Process		1											
Supplier		1											
Training	Ш												
Unapproved													
							AUL	T CATE	GORY				
Landi	_					General		1			7	<del></del>	~
	<b>├</b> ─	-			<u> </u>	Bend		Grain			Ovalized	Ļ	Pressure/Forced
Setup Other Process Supplier Training				O/S	BOM/Route		Hardwa			Over/Under	<del>                                     </del>	Temperature/Cure	
	<b>─</b>					Broken/Damaged	L	4	ion Incomplete		Part Incorre	<del></del>	Weld
	$\vdash$		nped			Burrs		i	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuff	s			<u></u>	Contamination		Mainte			Part Moved		
	$oldsymbol{oldsymbol{ ext{H}}}$					Countersink		Mislabe	eled		Positioned V		
	— `	ection St		Tube	<b> </b>	Cut Too Short	_	Misread	d		Power Loss/	Surge	Other
	<b>—</b>	les in Be			ļ	Drill Holes		Offset					
	Torque Waves in Extrusion				n	Drawing	1	Out of	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID: Parent Item: Parent Item Name:	101602 D4030-041 Long Basket Assembly (350)				te: 5/13/13 ty: 1.00	Required Date: 5/31/13 Required Qty: 1.00
NAS1149F0332P WASHER	Purchased	No	100 Eacl	h 8,438.0000	8	8 ~ 7.5
		<b>Location</b>	Loc Oty	Loc Code	•	,
·		GA	182			<u>_</u>
		122063	182			<u>.</u>
		ST294	158			<del></del>
		122063	158			_
		ST295	3			_
		123352	3		_	_
		st510	8095		10-00	<u>.</u>
		123900	8095		12390	10 -
NAS1149C0432R Washer	Purchased	No	100 Eac	th 1,612.0000	2	2 70 13-07-17
		<b>Location</b>	Loc Qty	Loc Code		·
		ST292	1612			
		119124	6			<del></del>

1606

122441

122441

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORM	MANCE / UPDATE		QA Closed:	Date:	
<u>u</u> .					DICOCCITION	1		0.50	INCT DE	PARTMENT,		
Work Orde	er:				DISPOSITION	1		AGA	IINST DE	PARTIVIENT <i>)</i>	PROCESS	
Part N					Scrap Machining Use-as-is Thermoforming			Machining Smal	Stube Water Jet Engineering all Fab Prod. Eng. Coor. Quality sishing Rec/Store/Packaging Other posite			Quality
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data							<del>-</del>					
Equip/Tooling												
Operator		1										
Material						1				!		
Setup												
Other		1									:	
Process												
Supplier												
Training												
Unapproved												
						AUL	T CATE	GORY				
Landi	ng Gear			_	General		ı		_	1	_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Not Conce	ntric to	o/s	BOM/Route	$\sqcup$	Hardwa			Over/Under	<del> </del>	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	Щ	1	ion Incomplete	`	Part Incorred		Weld
		I/Crimped		Ļ	Burrs	Ш	Į.	ions Incomplete/Unclear	_	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			_	Contamination	Щ	Mainte			Part Moved		
	Heat Tr	eat			Countersink		Mislabe	eled	[	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

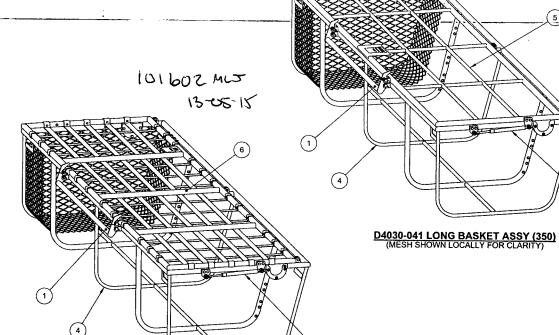
Cut Too Short

Drill Holes

Drawing

Finish

	ITEM	QTY -041	QTY -043	P/N	DESCRIPTION					
-		X		D4030-041	LONG BASKET ASSY (350)	1				
.4.			Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)	1				
						1				
	1	1	1	D2530	HANDLE WELDMENT	1				
	2	2	2	D2535	SPRING	1 .				
D	3	2	2	D2537	BUSHING	1/e\				
	4	1	1	D3913-041	LONG BASKET BASE ASSY (350)	123				
	5	1_		_D3914-041	LONG BASKET LID ASSY (350)	1				
	6		1	D3915-041	LIGHT LID ASSY-LONG BASKET	1				
	7	6	-6	D3917-3	WASHER	1				
ř	8	2	2	D3953-3	GAS SPRING STUD, LID	1				
4	9	2	2	D3953-7	GAS SPRING SPACER					
1	10	2	2	D3953-9	GAS SPRING WASHER	ĺ				
<u> </u>		2	2	D3953-17	GAS SPRING SPACER	1				
- 1	12	1	1	D3953-19	GAS SPRING BRACKET	1				
1	13	1 .	1	D3953-21	GAS SPRING BRACKET	İ				
į	14	1	1	D3969-3	SPRING					
44	-15	4	4	AN3-14A	BOLT					
	16	2		AN3-16A	BOLT					
- 1	17		2	AN3-20A	BOLT					
c	18	3	3	AN4-12	BOLT (DRILLED)					
C:	19	4	2	AN5-17A	BOLT					
14	20		2	AN5-21A	BOLT					
	21	3	3	AN310-4	NUT, CASTELLATED					
	22	2	2	AN310C4	NUT, CASTELLATED					
÷	23	6	6	MS21042L3	NUT					
*	24	4	4	MS21042L5	NUT					
ı	25	3	3	MS24665-151	COTTER PIN					
-	26	2	2	MS24665-300	COTTER PIN					
-	27	6	6	NAS1149F0432P	WASHER					
	28	4	4	NAS1149F0563P	WASHER					
	: 30	8	8	NAS1149F0332P	WASHER					
	31	2	2	NAS1149C0432R	WASHER					
	ŧ į		Æ.							



D4030-043 LONG BASKET ASSY, LIGHT LID (350) (MESH SHOWN LOCALLY FOR CLARITY)

OTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); OTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3). MB 10.07.23 В AN5-21A BOLT WAS AN5-19A: BOM & (D3-3) JPH 10.04.06 Α JPH 10.03.16 REV. BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. C D4030 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE DE APPR. DATE 10.07.23

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
71 WEIGHT: \_041- 72 lbs APPROX

7) WEIGHT: -041: 72 lbs APPROX -043: 57 lbs APPROX

